

# Work Order ID 105023

\*105023\*

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Item ID: D206-802-032 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Passenger Door Opener RH  
 Start Date: 7/23/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 7/23/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-07-24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9579	B
IIN D206-802-3	A

100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-802-032 CHG004								

105	Pick Kit	0.00							
*105*									
Packaging	Memo	0.00							
Packaging									

DAS  
31  
9-89

13-10-25 1 MLJ



DAS  
32  
9-89

7/31/25 U

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Rework  <input type="checkbox"/> Scrap  <input type="checkbox"/> Use-as-is  <input type="checkbox"/> Work Order Update         </div> <div> <input type="checkbox"/> Skid-tube  <input type="checkbox"/> Machining  <input type="checkbox"/> Thermoforming  <input type="checkbox"/> Large Fab         </div> <div> <input type="checkbox"/> Crosstube  <input type="checkbox"/> Small Fab  <input type="checkbox"/> Finishing  <input type="checkbox"/> Composite         </div> <div> <input type="checkbox"/> Water Jet  <input type="checkbox"/> Prod. Eng. Coord.  <input type="checkbox"/> Rec/Store/Packaging  <input type="checkbox"/> Supplier         </div> <div> <input type="checkbox"/> Engineering  <input type="checkbox"/> Quality  <input type="checkbox"/> Other         </div> </div>	
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**\*105023\***

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mk:  
13-10-25

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 105023  
Parent Item: D206-802-032  
Parent Item Name: Passenger Door Opener RH

Start Date: 7/23/13  
Start Qty: 1.00

Required Date: 7/23/13  
Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP Rev:B 11.10.25 AS PER  
DSI9579 REV.A DD verf:EC IPP Rev:C 11.12.19 PER DSI9579 REV B DD verf:EC  
IPP Rev:D 12.07.30 AS PER ECN12-624 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D3552-17</b> Door Prop		Manufactured	No			105	Each	21.0000	1	1	DAS 32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST261		21							
				101030		4							
				103639		12							
				91749		5							
<b>D3622-5</b> Ball Stud		Manufactured	No			105	Each	18.0000	2	2	DAS 32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		18							
				82314		2							
				85606		16							
<b>D4112-1</b> Aft Sill Doubler		Manufactured	No			105	Each	2.0000	1	1	DAS 32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST097		2							
				72212		2							
<b>D4115-5</b> Doubler		Manufactured	No			105	Each	4.0000	1	1	DAS 32 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST098		4							
				85047		4							

7

13/10/24  
(1)

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 105023  
Parent Item: D206-802-032  
Parent Item Name: Passenger Door Opener RH

Start Date: 7/23/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4S

RIVET

Purchased

No

105

Each

2,376.0000

4

4

DAS  
32  
9-89

## Location

## Loc Qty

## Loc Code

GA

5

6874

5

ST317

1371

6874

1371

ST334

1000

m125807

1000

DAS  
31  
9-89

6874

MS20600-AD4W2

Rivet

Purchased

No

105

Each

1,457.0000

14

14

DAS  
32  
9-89

## Location

## Loc Qty

## Loc Code

ST311

600

m125708

600

ST506

857

125578

857

DAS  
31  
9-89

m125578

MS21073L5

Anchor Nut

Purchased

No

105

Each

44.0000

2

2

DAS  
32  
9-89

## Location

## Loc Qty

## Loc Code

ST318

44

125654

44

DAS  
31  
9-89

125654

NAS1149G0532R

WASHER

Purchased

No

105

Each

810.0000

6

6

DAS  
32  
9-89

## Location

## Loc Qty

## Loc Code

GA

16

116513

16

ST292

294

125484

294

st510

500

m126319

500

DAS  
31  
9-89

DAS  
31  
9-89

125484

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NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



# Picklist Print

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Work Order ID: 105023  
Parent Item: D206-802-032  
Parent Item Name: Passenger Door Opener RH

Start Date: 7/23/13 Required Date: 7/23/13

Start Qty: 1.00 Required Qty: 1.00

**NAS1149C0563R**

Washer **DAS**  
**31**  
**9-89**

Purchased No

105 Each 360.0000

**DAS**  
**31**  
**9-89**

6 **DAS**  
**32**  
**9-89**

Location

Loc Qty

Loc Code

ST292  
120422  
m125928

360  
60  
300

120422

**D4108-11**

Template **DAS**  
**31**  
**9-89**

Manufactured No

105 Each 8.0000

**DAS**  
**31**  
**9-89**

1 **DAS**  
**32**  
**9-89**

Location

Loc Qty

Loc Code

ST095  
79297  
85048

8  
1  
7

85048

**D4108-047**

Sill Doubler Assembly **DAS**  
**31**  
**9-89**

Manufactured No

105 Each 2.0000

**DAS**  
**31**  
**9-89**

1 **DAS**  
**32**  
**9-89**

Location

Loc Qty

Loc Code

ST096  
79352

2  
2

79352

**GR3523-4-4**

Rivet **DAS**  
**31**  
**9-89**

Purchased No

105 Each 118.0000

**DAS**  
**31**  
**9-89**

4 **DAS**  
**32**  
**9-89**

Location

Loc Qty

Loc Code

ST330  
119717  
124259

118  
18  
100

119717

**D3552-27**

Door Prop

Manufactured No

105 Each 5.0000

**DAS**  
**31**  
**9-89**

1 **DAS**  
**32**  
**9-89**

Location

Loc Qty

Loc Code

ST261  
88104  
89499

5  
1  
4

88104

13/14/12 (1)

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Shop Packet Print

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0  
REF CANADIAN STC: SH10-44  
REF FAA STC: SR02933NY  
REF EASA STC: 10033253

## 1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

## 2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)  
52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH

### ADD:


	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
	4	CR3523-4-4	RIVET
	1	D3552-27	DOOR PROP




## 3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

105023 M/L5  
12-02-24

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
DATE: 11.12.07  
CERT. NO.: SH10-44  
ISSUE NO.: 1

B	ADD DOOR PROP D3552-27	AP	11.12.07
A	NEW ISSUE	MB	11.10.14
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9579	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		UPGRADE KIT	NTS
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#### 4.0 INSTALLATION CHANGE:

##### 4.1 On metal airframe:

No change. Install D206-802-032 using D4112-1 per Section 3.3 of IIN-D206-802-3.

##### 4.2 On composite airframe:

Install D206-802-032 by replacing D4112-1 Aft Sill Doubler with D4108-047 per instructions below and Figure 1 of this Service Instruction.

##### 4.2.1 Perform Step 3.3.1 of IIN-D206-802-3.

##### 4.2.2 Replace Steps 3.3.2 to 3.3.16 with the following:

- a) Using Figure 1 of this Service Instruction, locate D4108-11 Template on the edge of the door post closeout approximately 17.5" from the front of the seat. Match drill the Ø0.128" rivet holes (4 PL) on the door sill. Locate and drill thru template and door sill if the door sill is without existing holes.
- b) Transfer drill the Ø0.128" holes (4 PL) from D4108-11 Template to the D4108-047 Sill Bracket Assembly.
- c) Deburr all drilled holes and clean area.
- d) Remove and retain the Ball Stud and hardware from the D4108-047 Sill Bracket Assembly.
- e) Install D4108-047 Sill Bracket Assembly by applying a thin layer of Proseal 890 and wet installing the CR3523-4-4 Rivets (4 PL) as shown in Figure 1 of this Service Instruction.
- f) Remove excess Proseal, grind rivet stems flush and clean area of any debris.
- g) Re-install the Ball Stud and hardware removed at Step "d)" of this instruction.
- h) Re-position the carpet and interior trim panel. Trim/cut as required for the ball stud and to allow the D4108-047 Sill Bracket Assembly to protrude.
- i) Re-install the scuff plate.
- j) Install rod end of D3552-27 Door Prop onto the Ball Stud mounted on D4108-047 Sill Bracket Assembly.
- k) With the door open and using the D3552-27 Door Prop, Figure 4 and the dimensions shown as reference, position D4115-5 Doubler. Ensure that the door opens far enough for ingress and egress (minimum of 19" wide) and that there is no interference with any structure or interior trims. The final location of the D4115-5 Doubler will vary somewhat from aircraft to aircraft.

##### 4.2.3 Perform Steps 3.3.17 to 3.3.26 of Installation Instructions IIN-D206-802-3.

##### 4.2.4 Replace Step 3.3.27 with the following:

- a) Attach the cylinder end of the D3552-27 Door Prop to the D3622-5 Ball Stud installed on the previous step.



##### 4.2.5 Complete installation of D206-802-032 by following Steps 3.3.28 to 3.3.29 of Installation Instructions IIN-D206-802-3.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

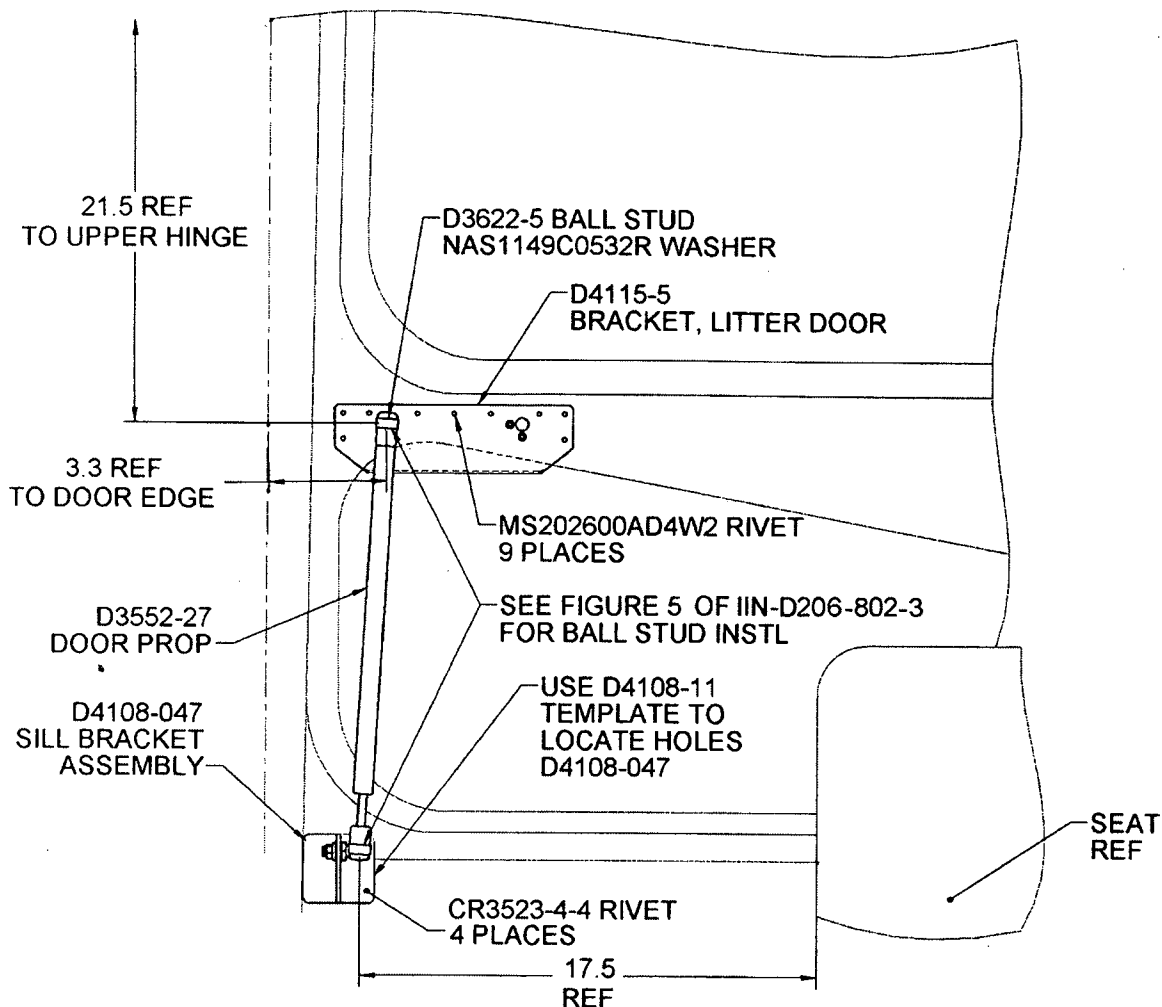
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MFG. APPR.	N/A	DSI 9579	SHEET 2 OF 3
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

**FIGURE 1: INSTALLATION OF D206-802-032 ON COMPOSITE AIRFRAME**

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AIRCRAFT CERTIFICATION  
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DAO # 01-O-01

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105023

REFERENCE ONLY

## 5.0 PARTS LIST

## 5.1 D206-802-029/-030 Crew Door Opener Kits

8/13-10-25

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

## 5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

DAS

6

9-89

## 1.0 PURPOSE:

It has come to Dart's attention that a portion of the airframe on recent Bell 206L4 aircraft is made of composite. In such cases, installing the D4112-1 (ref. D206-802-032 Kit) per IIN-D206-802-3 might not be possible. To that effect, Dart has created DSI 9579-011 Upgrade Kit to facilitate installation of D206-802-032 Kits at Change 001. The parts list of D206-802-032 Kits at Change 002 and later is amended as follows:

## 2.0 PARTS LIST CHANGE:

5.2 D206-802-031/-032 Passenger Door Opener Kits (IIN-D206-802-3 Rev. A)

52.4.9 D206-802-031/-032 Passenger Door Opener Kits (ICA-D407-802 Rev. 0)

Qty -031	Qty -032	Part Number	Description
<input checked="" type="checkbox"/>	<input type="checkbox"/>	D206-802-031	PASSENGER DOOR OPENER KIT, LH
<input type="checkbox"/>	<input checked="" type="checkbox"/>	D206-802-032	PASSENGER DOOR OPENER KIT, RH

### ADD:

<input type="checkbox"/>	1	D4108-11/	TEMPLATE
<input type="checkbox"/>	1	D4108-047	SILL DOUBLER ASSEMBLY
<input type="checkbox"/>	4	CR3523-4-4	RIVET
<input type="checkbox"/>	1	D3552-27	DOOR PROP

## 3.0 DSI-9579-011 UPGRADE KIT PARTS LIST:

Qty -011	Part Number	Description
<input checked="" type="checkbox"/>	DSI 9579-011	UPGRADE KIT
1	D4108-11	TEMPLATE
1	D4108-047	SILL DOUBLER ASSEMBLY
4	CR3523-4-4	RIVET
1	D3552-27	DOOR PROP

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01




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Work Order ID 105023

\*105023\*

July-23-13 1:00:44 PM

Item ID: D206-802-032

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Passenger Door Opener RH

Start Date: 7/23/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan: MLS

Date: 13-07-24

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9579

B

IIN D206-802-3

A

0.00

100

DOCUMENT CONTROL

\*100\*

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-032 CHG004

105

Pick Kit

0.00

\*105\*

Packaging

Memo

0.00

Packaging

MLS 13-10-24

DAS  
32  
9-89